

Date: Friday, 10/12/2007 8:34:56 AM  
 User: Eric Charbonneau

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services

Drawing Name : WELDMENT TOP PANEL

Job Number : 35149

Estimate Number : 13030

P.O. Number :

This Issue : 10/12/2007 S.O. No. :

Prsht Rev. : NC

First Issue : / / Type : SMALL /MED FAB

Previous Run :

Written By : \_\_\_\_\_

Checked &amp; Approved By : \_\_\_\_\_

Comment : Est Rev:A New Issue 07-09-27 DD verified by: EC

Part Number : D36505

Drawing Number : D3650 UNDER REVIEW

Project Number : N/A

Drawing Revision : U/R

Material :

Due Date : 10/19/2007

FOR ENGINEERING USE ONLY

**PROTOTYPE**

Qty: 2 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation:

Description :

1.0 M304S24GA

304/316 .025 Sheet



Comment: Qty.: 0.8537 sf(s)/Unit Total : 1.7073 sf(s)

304/316 SS sheet 24 ga (0.025" thick)

Batch: 105592 LB 07-10-15

CERTIFICATE OF CONFORMITY  
REQUIRED

2.0 WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3650

Dwg Rev: PRE

Prog Rev: PRE

2-Deburr if necessary

LB 07-10-15

3.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8

SECOND CHECK



Comment: SECOND CHECK

PC 07-10-16

**ENGINEERING  
APPROVAL**

5.0 BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D3650

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Drawing Name: WELDMENT TOP PANEL

Job Number: 35149

Part Number: D36505

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



**ENGINEERING  
APPROVAL**



Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and stock 

Location: \_\_\_\_\_

**FOR ENGINEERING USE ONLY**

8.0

QC21

FINAL INSPECTION/W/O RELEASE

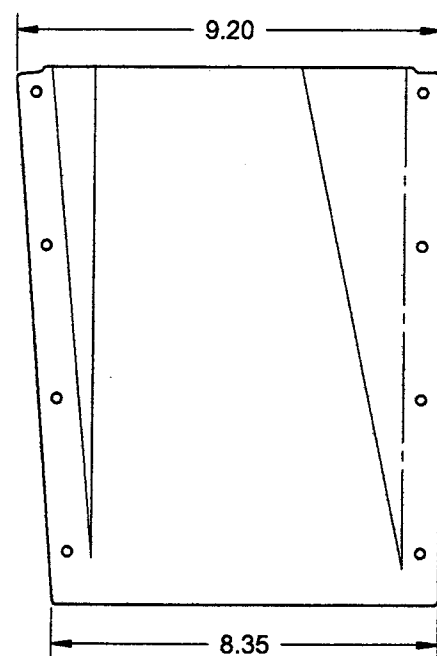
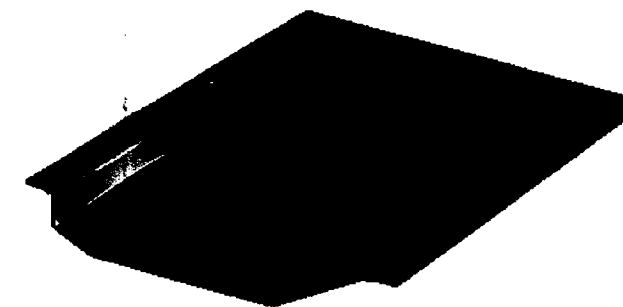
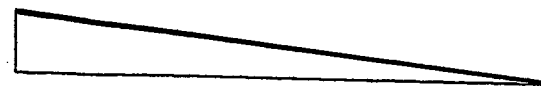
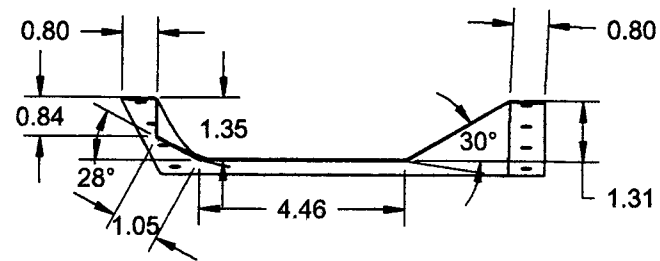


Comment: FINAL INSPECTION/W/O RELEASE

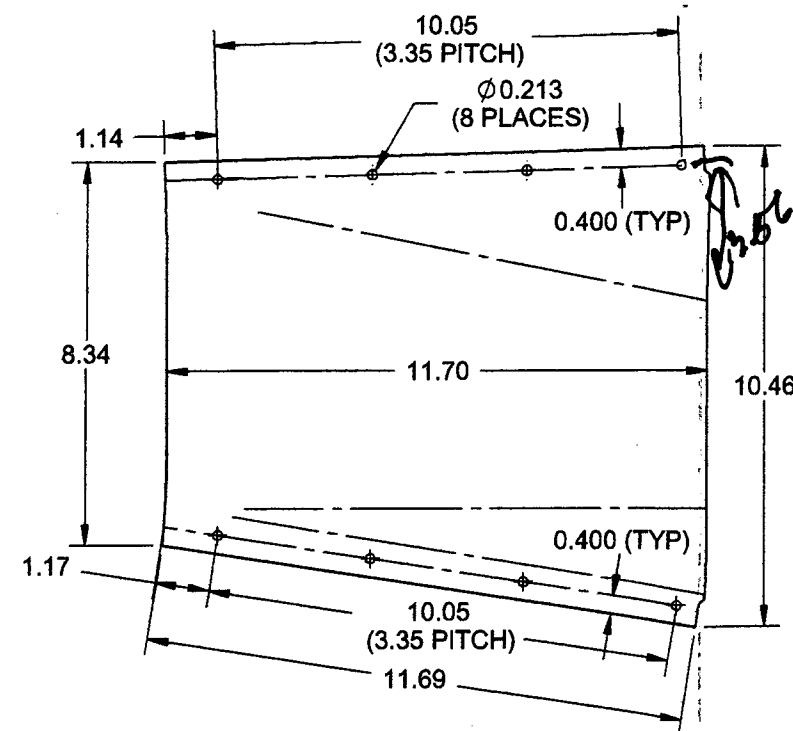
Job Completion



*W* 17.11.22



**D3650-5 CENTER PANEL**  
(MAKE FROM D3650-5F FLAT PATTERN)



**D3650-5F FLAT PATTERN**

**NOTES:**

- 1) MATERIAL: AISI 304/316 SAINLESS STEEL 0.025 (24 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S24GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MACHINE PER DRAWING "D3650.A4"

DESIGN RF	DRAWN BY RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED DS	APPROVED	DRAWING NO. <b>D3650</b>	REV. A SHEET 4 OF 4
DATE <b>07.09.10</b>		TITLE <b>WELDMENT TOP PANEL</b>	SCALE 1:4
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DART AEROSPACE LTD		Work Order:	35149
Description: WELDMENT TOP PANEL		Part Number:	3650-3
Inspection Dwg: 3650 Rev: PRE		Page 1 of 1	

## FIRST ARTICLE INSPECTION CHECKLIST

**X**

[illegible]

Measured by:	HB	Audited by:		Prototype Approval:	
Date:	07-10-15	Date:		Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	